

Work Order ID 68706

Wednesday, April 20, 2011 8:35:03 AM



Page 1

Item ID:	D3437-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Aft Strut Assembly					
Start Date:	4/20/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	4/25/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-04-20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3437	Rev B								

100
 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab Assemble as per Dwg D3437Dwg Rev:

110
 QC 0.00
 Quality Control Memo 0.00

120
 Packaging 0.00
 Packaging Memo 0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


Work Order ID 68706

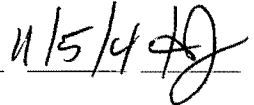
Wednesday, April 20, 2011 8:35:03 AM

Page 2

Item ID: D3437-043 Accept  Setup Start 
Revision ID: Stop 
Item Name: Aft Strut Assembly
Start Date: 4/20/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 4/25/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/5/4 
11-05-3
(4)

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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 20, 2011 8:35:10 AM

Page 1

Work Order ID: 68706

Parent Item: D3437-043

Parent Item Name: Aft Strut Assembly



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.05.20 New Issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C516 WASHER		Purchased	No			100	Each	55.0000	2	8			
<div> <div>Location</div> <div>ST347</div> <div>102842</div> </div> <div> <div>Loc Qty</div> <div>55</div> <div>55</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3437-1 Foot		Manufactured	No			100	Each	16.0000	1	4			
<div> <div>Location</div> <div>ST508</div> <div>44787</div> <div>46046</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>4</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3437-3 Clip		Manufactured	No			100	Each	42.0000	1	4			
<div> <div>Location</div> <div>ST508</div> <div>43175</div> </div> <div> <div>Loc Qty</div> <div>42</div> <div>42</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3437-9 Eyebolt		Manufactured	No			100	Each	11.0000	1	4			
<div> <div>Location</div> <div>ST508</div> <div>43815</div> <div>44790</div> </div> <div> <div>Loc Qty</div> <div>11</div> <div>3</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

E 5/11/05/03

8
E 5/11/05/03

3
1
E 5/11/05/03

4
E 5/11/05/03

2
2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 20, 2011 8:35:10 AM

Page 2

Work Order ID: 68706

Parent Item: D3437-043

Parent Item Name: Aft Strut Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

100

Each

558.0000

1

4



Nut

EP 4/05/03

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

538

112314

438

116548

100

4

W/O:		WORK ORDER CHANGES					
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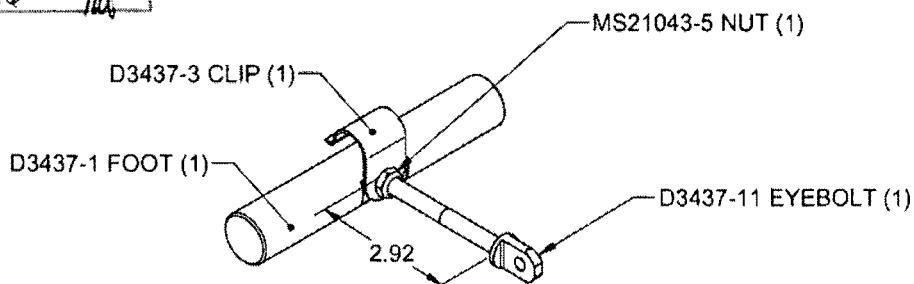
NOTE: Date & initial all entries



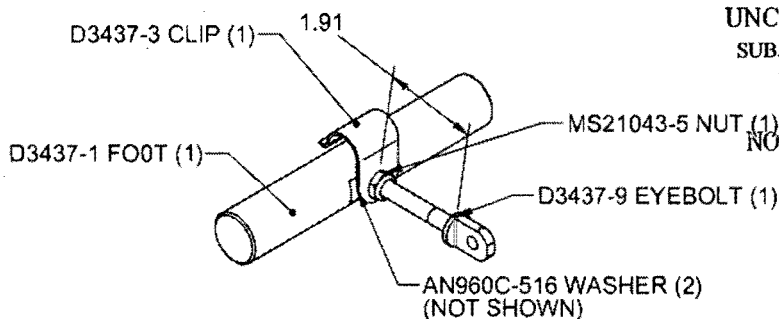
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 1 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED

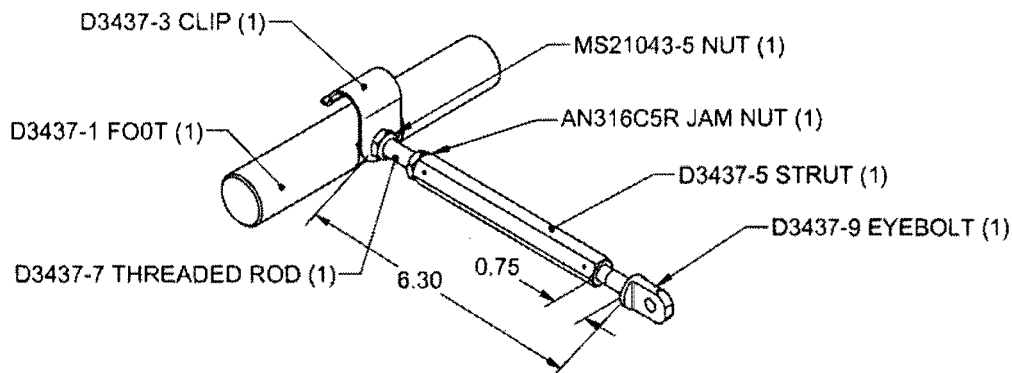
05.08.11 *[Signature]*



D3437-041 AFT STRUT ASSEMBLY



D3437-043 AFT STRUT ASSEMBLY



D3437-045 AFT STRUT ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *48706*

01/11-04-20

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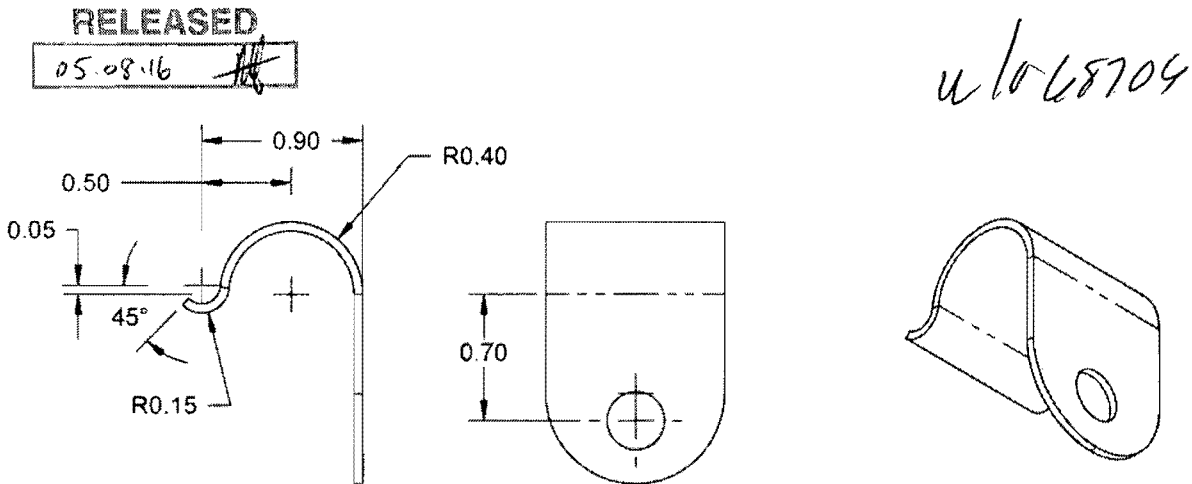
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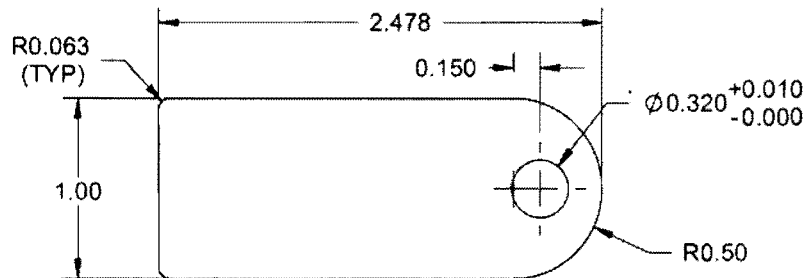
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2



D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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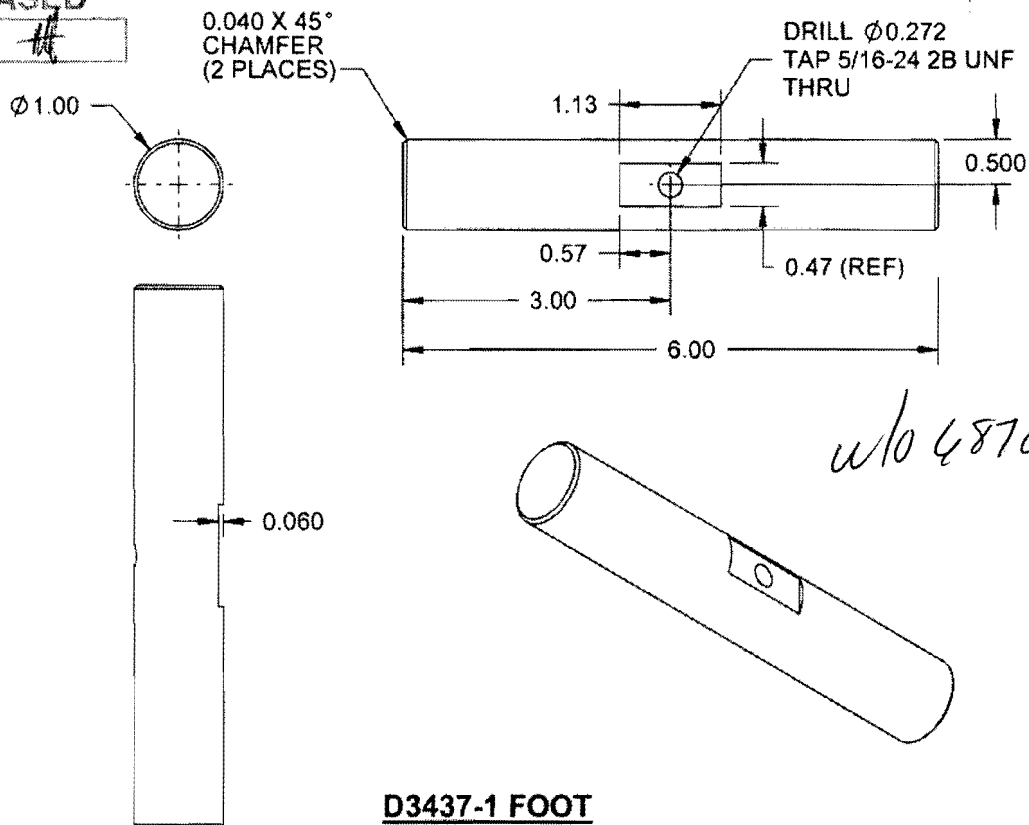
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 3 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

RELEASED

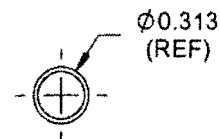
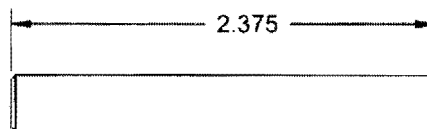
05-08-16 *[Signature]*



D3437-1 FOOT

D3437-1 FOOT:

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR
(REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



D3437-7 THREADED ROD

D3437-7 THREADED ROD:

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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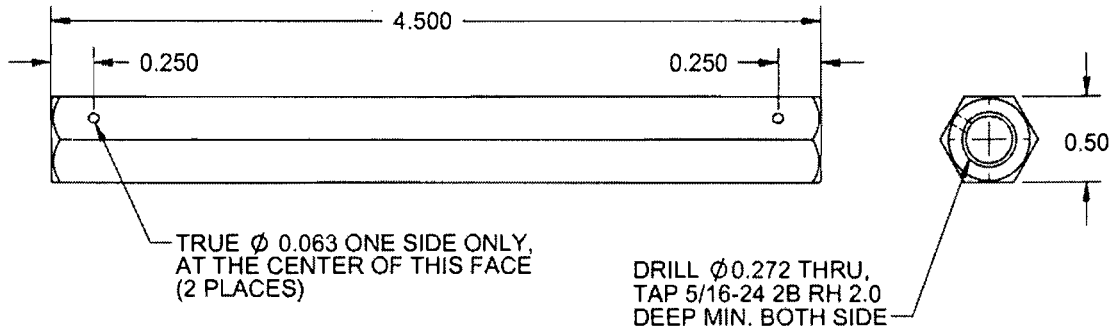
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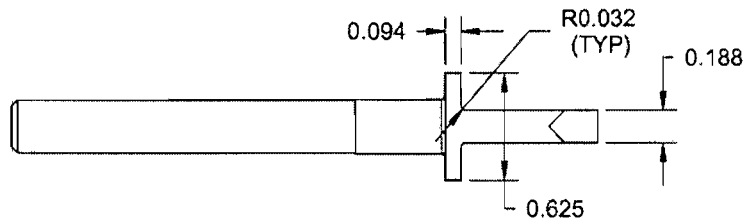
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 4 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2



D3437-5 STRUT:

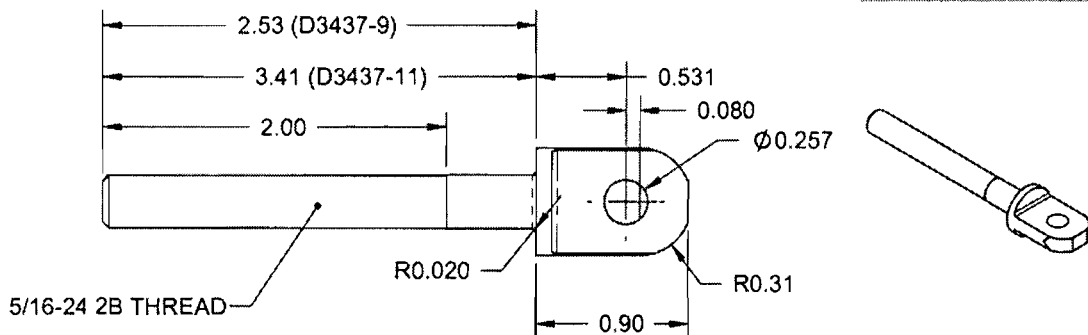
- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

u/o 68706



RELEASED

05-08-16 *[Signature]*



D3437-9/-11 EYEBOLT:

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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